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D119-675-112
Job Sheet 198869



Part No: D119-675-112

Job Qty: 3 pcs

Part Name: Heli-Access-Step™ RH - DART Crosstube Compatible

DAS
21
9-09

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/7/19

Job Tracking No:

Due Date: 12/5/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP REV:A 15.11.09 PER IIN REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	3 pcs	12/5/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		



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Container No: S231166



Part: D119-675-112

Job No: 198869

Serial No/Batch: S231166

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SR00948SE 15/10/28, TC-LoA C-11.

				Packaging 1 - 32	
				Packaging 1 - 33	
				Packaging 1 - 34	
				Packaging 1 - 35	
				Packaging 1 - 36	
120 QC 4	3 pcs	12/5/19	0.00 0.00	QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	
				QC 4 - 75	
130 Packaging 3-1 - Stock - B4B	3 pcs	12/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
135 DC - 1 - B4B	3 pcs	12/5/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	
140 QC 21 - FG	3 pcs	12/5/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	
Part Op 120 - (QC4- 100% Inspect kits for completeness)					
Descriptions: 130 - Identify and pack for shipping as per PPP D119-675-112 Location : FG107					
135 - Photocopy bluefile & type labels per PPP D119-675-112 CHG001					
140 - (QC21- Final Inspection - Work Order Release)					

(012793)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-15A	Bolt	12 Ea (4 ea) ✓	110-Packaging 1 - Pick Kit	5216209 ✓
AN4-16A	Bolt	12 Ea (4 ea) ✓	110-Packaging 1 - Pick Kit	5228325 ✓
AN4-22A	Bolt	12 Ea (4 ea) ✓	110-Packaging 1 - Pick Kit	5167444 ✓
D2617-3	Bushing	12 pcs (4 ea) ✓	110-Packaging 1 - Pick Kit	5197583 ✓
D2617-5	Spacer	12 pcs (4 ea) ✓	110-Packaging 1 - Pick Kit	5210729 ✓
D2732-032	Rubber Cushion - 3.2"	24 pcs (8 ea) ✓	110-Packaging 1 - Pick Kit	5199240 x 111 ✓ 32092106
D3043-042	Step Weldment RH	3 pcs (1 ea)	110-Packaging 1 - Pick Kit	5221680 ✓
D5283-041	Basket Clamp Assembly	6 pcs (2 ea) ✓	110-Packaging 1 - Pick Kit	5160190 ✓
D5283-043	Basket Clamp Assembly	6 pcs (2 ea)	110-Packaging 1 - Pick Kit	5229604 ✓
D5283-11	Basket Clamp	6 pcs (2 ea) ✓	110-Packaging 1 - Pick Kit	5116156 ✓
D5283-7	Basket Clamp	6 pcs (2 ea) ✓	110-Packaging 1 - Pick Kit	5116111 ✓
MS21042L4	Nut	36 Ea (12 ea) ✓	110-Packaging 1 - Pick Kit	5225610 ✓
NAS1149D0463J	Washer	72 Ea (24 ea) ✓	110-Packaging 1 - Pick Kit	5225595 ✓

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	AN4-15A	12	160	0
	AN4-16A	12	503	0
	AN4-22A	12	105	0
	D2617-3	12	70	0
	D2617-5	12	15	0
	D2732-032	24	40	0
	D3043-042	3	0	0
	D5283-041	6	11	0
	D5283-043	6	3	0
	D5283-11	6	33	0
	D5283-7	6	28	0
	MS21042L4	36	1,833	0
	NAS1149D0463J	72	4,493	0

Part Specifications

Specifications could not be found.

Plex 8/20/19 11:42 AM Dart.lajeunesse.marie

667 205



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐ ☐ ☐
Scrap ☐ ☐ ☐
Use-as-is ☐ ☐ ☐

DEPARTMENT/PROCESS

Skid-tube ☐ ☐ ☐
Machining ☐ ☐ ☐
Large Fab ☐ ☐ ☐

Cross tube ☐ ☐ ☐
Small Fab ☐ ☐ ☐
Finishing ☐ ☐ ☐

Eng. (Non-AW) ☐ ☐ ☐
Prod. Eng. Coord. ☐ ☐ ☐
Rec/Store/Packaging ☐ ☐ ☐

Engineering ☐ ☐ ☐
Water Jet ☐ ☐ ☐
Supplier ☐ ☐ ☐
Quality ☐ ☐ ☐

Date: _____ Sequence #: _____

QTY Affected: _____

MRB (QS042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐ ☐ ☐
Manufacturing Process ☐ ☐ ☐
Equip/Tooling ☐ ☐ ☐
Handling/Preservation ☐ ☐ ☐
Material ☐ ☐ ☐
Product Improvement ☐ ☐ ☐
Process Improvement ☐ ☐ ☐
Human Factors ☐ ☐ ☐

FAULT CATEGORY

Pressure/Forced ☐ ☐ ☐
Bending ☐ ☐ ☐
Crushing ☐ ☐ ☐
Cracks ☐ ☐ ☐
Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐
Marks/Chatter ☐ ☐ ☐
Mislabeled ☐ ☐ ☐
Other/Details: _____

Contamination ☐ ☐ ☐
Misaligned/off center ☐ ☐ ☐
BOM/Route ☐ ☐ ☐
Broken/Damage/Defect ☐ ☐ ☐
Incomplete/Unclear Instructions ☐ ☐ ☐
Drill Holes ☐ ☐ ☐
Fit/Function ☐ ☐ ☐

Power Loss/Surge ☐ ☐ ☐
Folio/Program ☐ ☐ ☐
Grain Direction ☐ ☐ ☐
Weld ☐ ☐ ☐
Wrong Stock Pulled ☐ ☐ ☐
Out of Sequence ☐ ☐ ☐
Off-set/Set-up ☐ ☐ ☐

Positioned Wrong ☐ ☐ ☐
Outside Tolerance ☐ ☐ ☐
Drawing ☐ ☐ ☐
Finish ☐ ☐ ☐
Part Lost/Missing ☐ ☐ ☐
Misread ☐ ☐ ☐

5.0 PARTS LISTS

5.1 Heli-Access-Step™ Parts List

ITEM	Qty -011	Qty -012	Qty -111	Qty -112	Part Number	Description
	X				D119-675-011	HELI-ACCESS-STEP™, LH
		X			D119-675-012	HELI-ACCESS-STEP™, RH
			X		D119-675-111	HELI-ACCESS-STEP™, LH
				X	D119-675-112	HELI-ACCESS-STEP™, RH
1	4	4	4	4	D2617-5	BUSHING
2	4	4	4	4	D2617-3	BUSHING
3	8	8	8	8	D2732-032	RUBBER CUSHION
4	1		1		D3043-041	STEP WELDMENT LH
5		1		1	D3043-042	STEP WELDMENT RH
6	4	4			D3041-1	CLAMP
7	2	2			D3041-3	CLAMP
8	4	4			D3041-5	CLAMP
9	2	2			D3041-7	CLAMP
10			2	2	D5283-7	CLAMP
11			2	2	D5283-11	CLAMP
12			2	2	D5283-041	CLAMP
13			2	2	D5283-043	CLAMP
14	4	4	4	4	AN4-15A	BOLT
15	8	8	4	4	AN4-16A	BOLT
16			4	4	AN4-22A	BOLT
17	24	24	24	24	NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

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